**Work Order ID 87022**

*Monday, July 09, 2012 8:59:25 PM*

*87022*

**Item ID:** D4522-13

**Accept** *N900040100*

**Setup Start** *NS1*

**Stop** *NS2*

**Revision ID:**

**Item Name:** Handle Shaft Adapter

**Start Date:** 7/10/2012 **Start Qty:** 2.00 *2*

**Required Date:** 7/18/2012 **Req'd Qty:** 2.00 *2*

**Cust Item ID:**

**Customer:**

**Reference:** 12.07.09.

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

**QC:** ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D4522 | B |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|
| 100 *100* Doosan Doosan Lathe | Memo TURN AS PER DWG AND FOLIO FB123 FOLIO REV: N/A DWG REV: B DEBURR | 0.00 / 0.00 | 2 | 0 | | |
| 110 *110* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 / 0.00 | 2 | 0 | | |

12/7/17 DAS 13

12/7/17 DAS 13

**Work Order ID 87022** *87022*

*Monday, July 09, 2012 8:59:25 PM*

**Item ID:** D4522-13 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

**Revision ID:**

**Item Name:** Handle Shaft Adapter

**Start Date:** 7/10/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

**Required Date:** 7/18/2012 **Req'd Qty:** 2.00 *2* **Customer:**

**Reference:**

**Run Start** *NR1* **Stop** *NR2*

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| | Memo | 0.00 | [signature] 12.07.18. | | | 2 | Ø | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: ST 17 | 0.00 | | | | [initials] | | | [initials] 12-7-19 |
| | Memo | 0.00 | | | | | | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release | 0.00 | | | | | 12/7/2019 [initials] | | |
| | Memo | 0.00 | | | | | | | |

MF 12-07-19

# Picklist Print

*Monday, July 09, 2012 8:59:25 PM*



**Work Order ID:** 87022

**Parent Item:** D4522-13

**Parent Item Name:** Handle Shaft Adapter

**Start Date:** 7/10/2012 **Required Date:** 7/18/2012

**Start Qty:** 2.00 **Required Qty:** 2.00

**Comments:** IPP REV:A NEW ISSUE 12-01-04 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **M303R1.000**<br>303 Round Bar 1.00 | | Purchased | No | | | | f | 5.9822 | | **0.3578947** | | | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| MAT028 | 5.982157895 | |
| 120866 | 0.7 | |
| 121070 | 3.31515789 | |
| 121282 | 0.45 | |
| 121728 | 1.517 | |

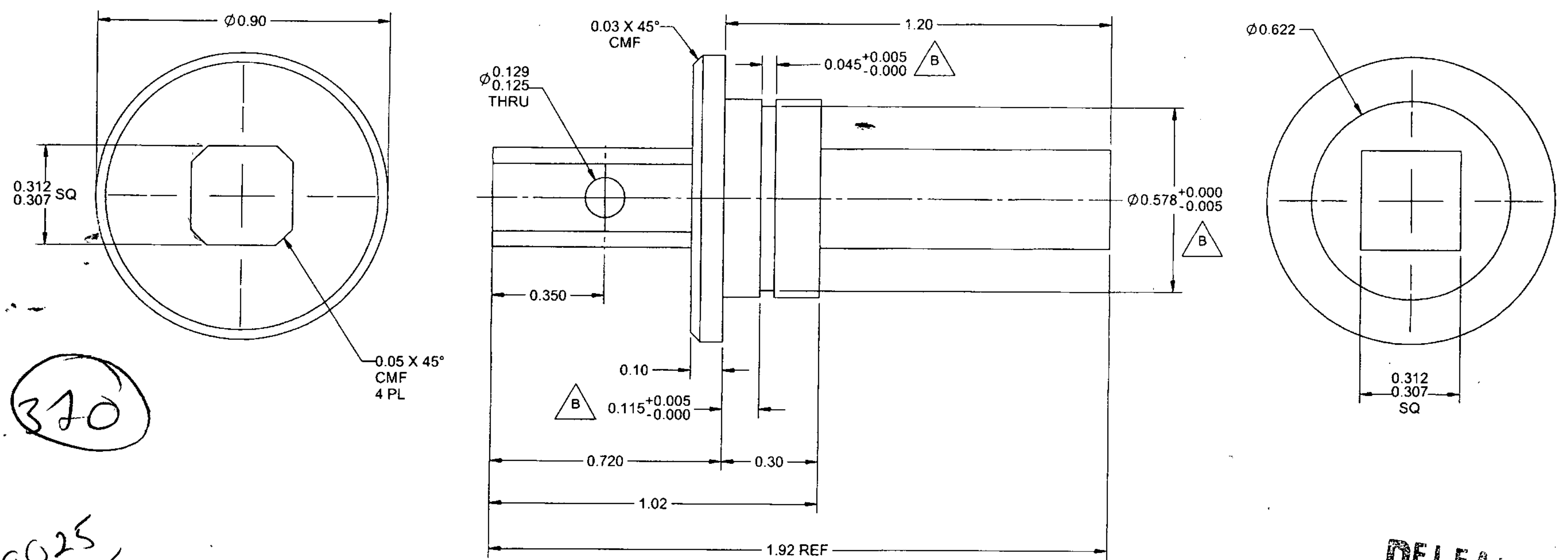
122386

.4 ft

12/12/12

DAS 13

.441 ,097344




320

.0025 .005 .0707

#86619

RELEASED 2012-06-13

**D4522-13 HANDLE SHAFT ADAPTER**

NOTES:

1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303R1.00 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R1.00
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER DART QSI 044 6.6
7) WEIGHT: 0.08 lbs

| | | |
|---|---|---|
| DESIGN | RP | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RP | DRAWING NO. D4522 — REV. B — SHEET 16 OF 23 |
| CHECKED | | |
| MFG. APPR. | | TITLE DOOR LATCH ASSY (412) — SCALE NTS |
| APPROVED | | |
| DE APPR. | | |
| DATE | 12.04.17 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 86619 |
|---|---|---|
| Description: Handle Shaft Adapter | Part Number: | D4522-13 |
| Inspection Dwg: D4522 Rev: B | | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø.90 | ±.030 | Ø.899 | ✓ | | SL-9 | [illegible] |
| .307-.312 | N/A | .312 | ✓ | | SL-5 | [illegible] |
| .05X45 | ±.030 | .05X45° | ✓ | | | |
| | | | | | | |
| Ø.125-.129 | N/A | .128 | ✓ | | | |
| .350 | ±.010 | .347 | ✓ | | | |
| .03X45° | ±.030 | .03X45° | ✓ | | | |
| 1.20 | ±.030 | 1.20 | ✓ | | | |
| .045 | +.005/-.000 | .0455 | ✓ | | | |
| Ø.578 | +.000/-.005 | Ø.578 | ✓ | | | |
| 1.92 | ±.030 | 1.922 | ✓ | | | |
| 1.02 | ±.030 | 1.027 | ✓ | | | |
| .30 | ±.030 | .301 | ✓ | | | |
| .720 | ±.010 | .723 | ✓ | | | |
| .115 | +.005/-.000 | .116 | ✓ | | | |
| .10 | ±.030 | .100 | ✓ | | | |
| | | | | | | |
| Ø.622 | ±.010 | Ø.622 | ✓ | | | |
| .307-.312 | N/A | .312 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | DAS 13 | Audited by: | [signature] | Preliminary Approval: | |
|---|---|---|---|---|---|
| Date: | 12/7/17 | Date: | 12-07-18 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| E | 10.04.14 | Added preliminary approval | KJ | |

[signature] 10.04.15